

Work Order ID 78304

January-05-12 8:30:01 AM

Ship March 23

78304

Page 1

Item ID: D2282-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: T Assembly

Stop *NS2*

Start Date: 05/01/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/01/05

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration as per dwg D2282
*****brush weld right after welding, to take color off *****
A/RER316L SS Filling Rod 11/5778

12-02-27 50x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12-02-28

50x

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble

12-3-3

50x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: T Assembly
 Start Date: 05/01/2012 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		5/2/13/16		counted (x10) 25/05			
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00							6/4/3/16 (50)
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/3/16 (50)

1203-4
(50)

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Picklist Print

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Work Order ID: 78304

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Parent Item: D2282-041

D2282-041

Parent Item Name: T Assembly

Start Date: 05/01/2012

Required Date: 23/03/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-3		Manufactured	No			100	Each	38.0000	1	50			
D2282-3									**				
Tube													

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

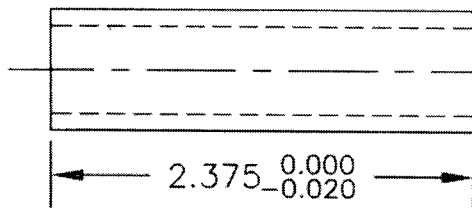
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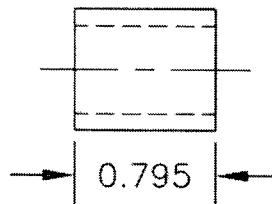


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

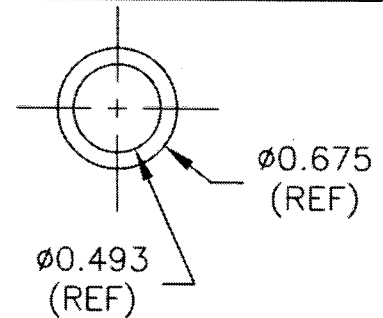
RELEASED
[Signature]
05/09/16



D2282-3

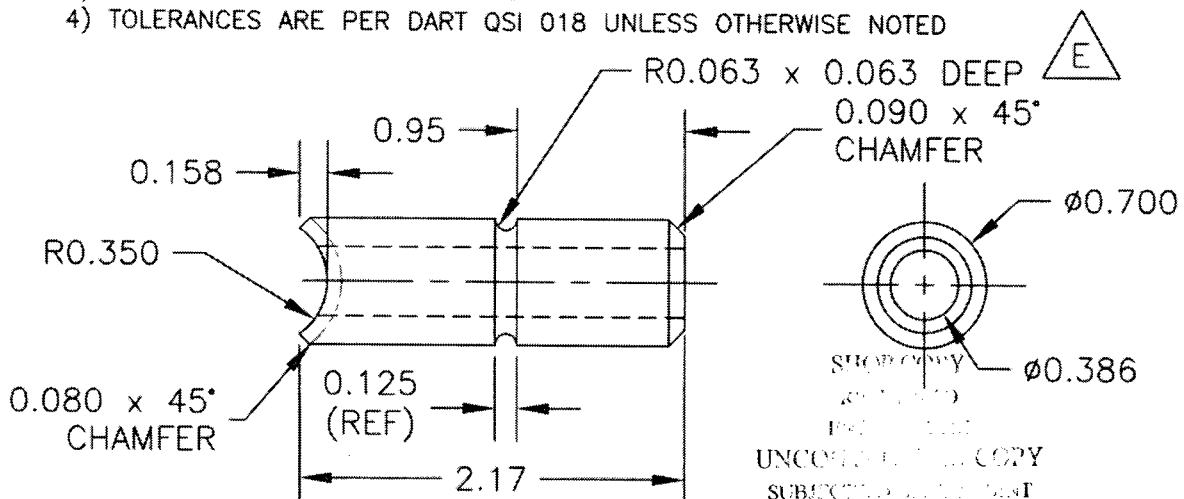


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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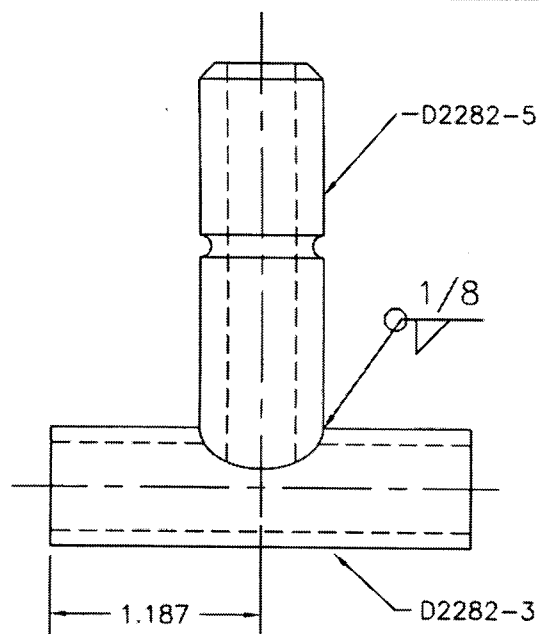
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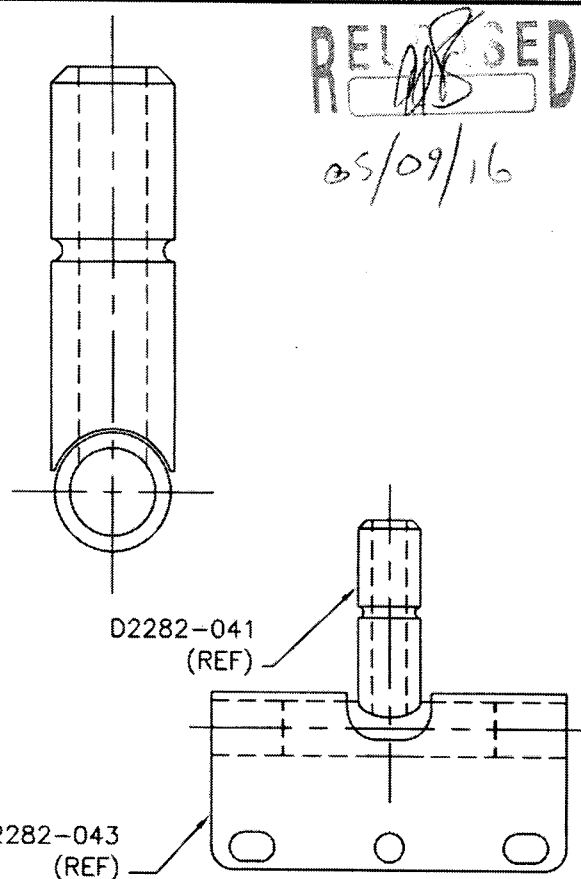


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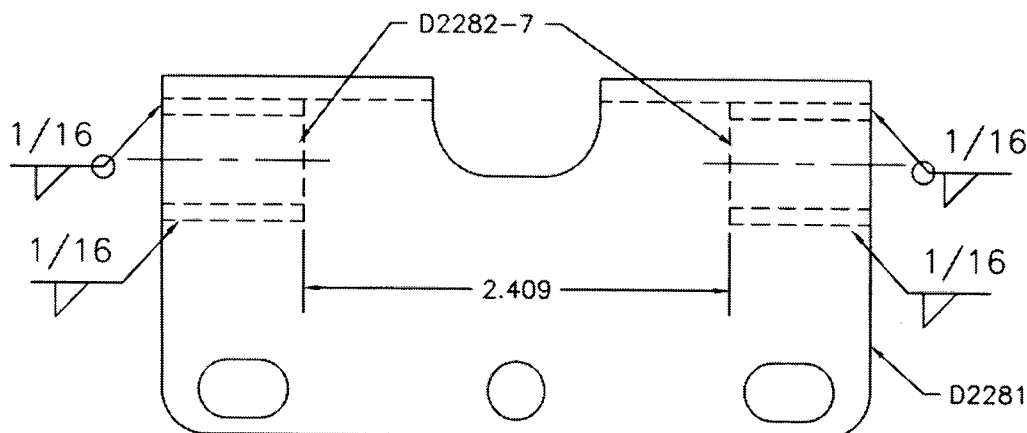
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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